

Order 12314



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3646-3

Job Sheet 189219



Part No: D3646-3

Job Qty: 6 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/23/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV C IPP Rev. A new issue 07.07.25 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - Brake NC	6 pcs	2/23/19	2/23/19	0.00	2.71	Small Fab - Brake - 1		9-89	FEB 04 2019
							Small Fab - Brake - 2			
							Small Fab - Brake - 3			
110	Small Fab - 2 - B4B	6 pcs	2/23/19	2/23/19	0.00	3.70	Small Fab - 1 - B4B		9-89	FEB 04 2019
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
120	QC 5	6 pcs	2/23/19	2/23/19	0.00	0.00	QC 5 - 10		9-89	FEB 04 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
130	Powdercoat - 4 Black Sand - B4B	6 pcs	2/23/19	2/23/19	0.00	0.20	Powdercoat - 1 - B4B		9-89	FEB 19-03-07
							Powdercoat - 2 - B4B			

140 QC 3	6 pcs	2/23/19	0.00 0.00	Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	DAS
				QC 3 - 68	40
				QC 3 - 9	9-89
					MAR 07 2019
150 Packaging 3-1 - Stock - B4B	6 pcs	2/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 -	

				B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	ST 377
				Packaging 3 - 28 - B4B	8 MAR 13 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	6 pcs	2/23/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70

Part Op 100 - (Form as per dwg)
 Descriptions: 110 - (Small Fab)
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3)
 140 - (QC3- Inspect Part Finish)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

M138940 START: 10:15 TEMP: 320° FINISH: 10:45

Job BOM

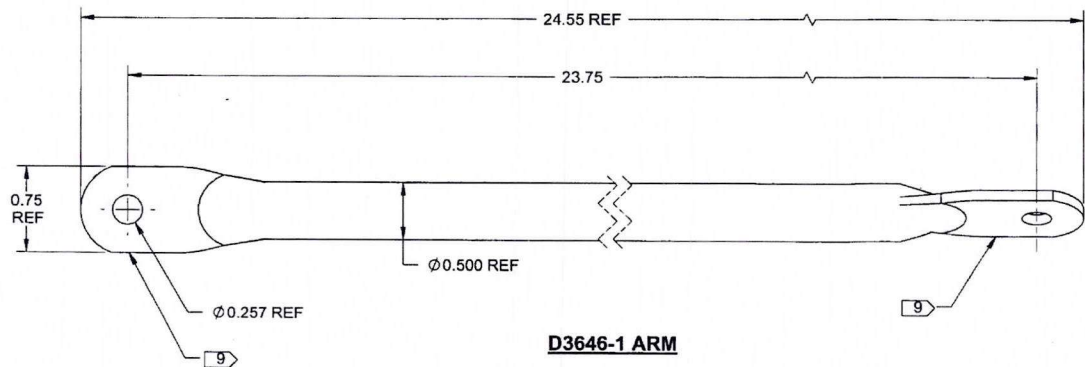
Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	17.4600 ft (2.91 ea)	100-Small Fab - Brake NC	3149127

Job Allocations

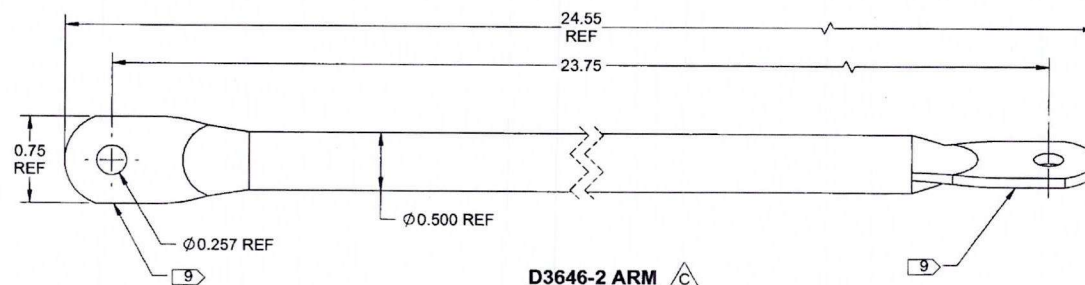
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Brake NC	M304TR0.500W.035	17	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	26.500Inches ± 0.130	26.630 26.370		
2	Arm	2.500Inches ± 0.130	2.630 2.370		
3	Arm	5.750Inches ± 0.130	5.880 5.620		
4	Arm	15.000Degrees ± 0.500	15.500 14.500		
5	Arm	45.000Degrees ± 0.500	45.500 44.500		
6	Arm	30.000Degrees ± 0.500	30.500 29.500		



D3646-1 ARM



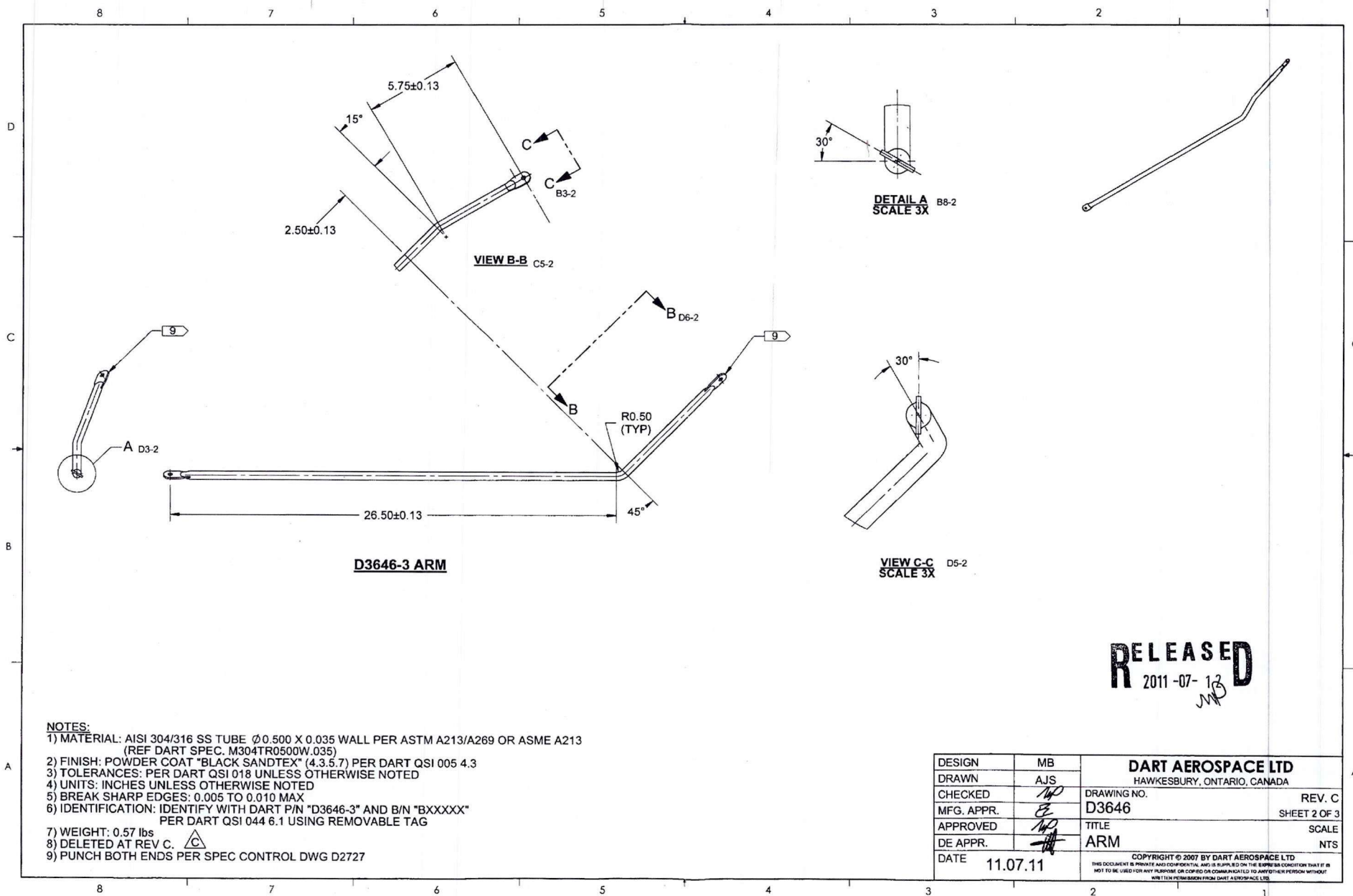
D3646-2 ARM

NOTES:

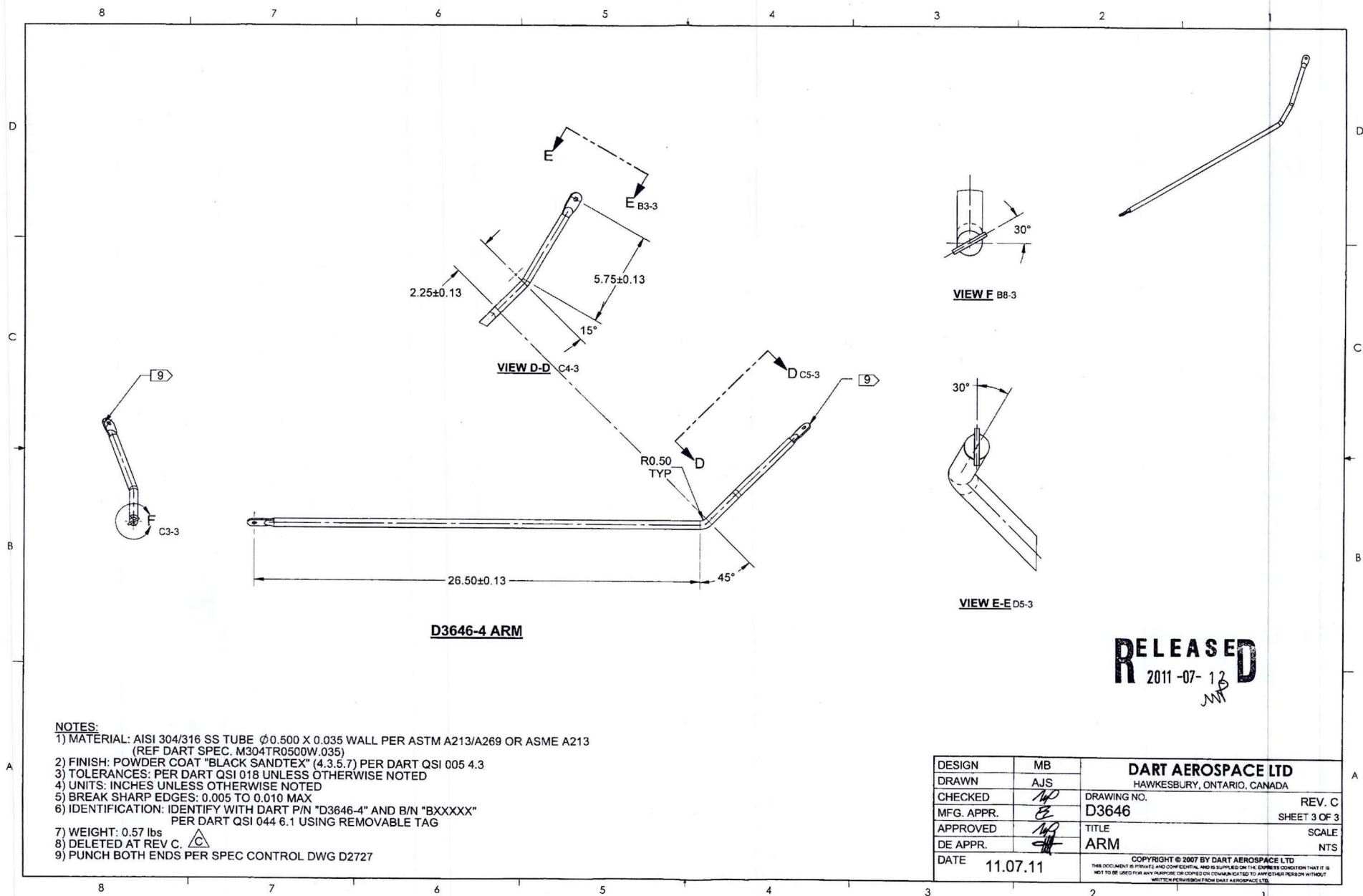
- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) DELETED AT REV. C
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

C	ADD-2 & -4 FOR LHS INSTALLATION. DELETE REFERENCES TO TEMPLATES (NOTE 8) PER SHOP REQUEST.	AJS	11.07.11
B	REFORMAT DWG. ANGLE 65° WAS 45° (ZN C3-1). ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	BE	D3646	SHEET 1 OF 3
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	ARM	NTS
DATE	11.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2011-07-12



RELEASED
 2011-07-13
 JM



RELEASED
2011-07-13
JMP

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-4" AND B/N "BXXXXX" PER DART QSI 044 6.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.57 lbs
- 8) DELETED AT REV C. $\triangle$
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	D3646	SHEET 3 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	ARM	NTS
DATE	11.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Email: sales@dartaero.com
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Container No: S150478



Part: D3646-3

Job No: 189219

Serial No/Batch: S150478

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/04/19